

Date: Tuesday, 09/09/2008 9:24:41 AM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-633-025
Job Number	: 41911		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D205633025
This Issue	: 09/09/2008 S.O. No. :	Drawing Number	: R08-073
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 16/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08.9.09</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D205633025	Heli Access Step LH Extended High Gear (
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Heli Access Step LH Extended High Gear (
 Original B34975 @ CHG001

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Re-stock the following items with the same batch #'s:

2x D2022-101 B21505 ✓

2x D2022-103 B16062 ✓

2x AN44-7A (eyebolt) M17614 *JUST ONE* ✓

1x AN4-5A M15247 ✓

3x AN4-6A M16067 ✓

2x AN4-7A M16199 *JUST ONE* ✓

1x AN4-14A M14600 ✓

1 - 1x AN4-10A M15003 ✓

1x AN5-14A M11921 ✓

14x AN960JD516 M16941 ✓

1 - 4x AN960JD516 M16521 ✓ *16527* ✓

1 - 8x MS21042L4 M15924 ✓

2x MS21042L5 M16822 ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 9:24:41 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-633-025

Job Number: 41911

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick the following:

*** re-identify the D3437-045 aft strut assembly with this new batch # ***

5.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: B21505

B29880

SL

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: B16062

SL

7.0

D2562005

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B03224

SL

8.0

D3437045

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Strut Assembly

Batch: B41911

SL

9.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M15247

SL

10.0

AN46A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M16067

8/9/9

(1x)

SL

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 9:24:41 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-633-025

Job Number: 41911

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	AN47A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M16199

SP

12.0	AN412A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M105143

SP

13.0	AN414A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M14600

SP

14.0	AN44 7A	EYEBOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYEBOLT

Batch: M1764

*****ENSURE THIS IS AN44-7A EYEBOLT*****

SP

15.0	AN514A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M11921

SP

16.0	AN960JD416	Washer
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Batch: M16941

SP

17.0	AN960JD516	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M16521

8/9/9

(1)

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 9:24:41 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-633-025

Job Number: 41911

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS21042L4

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch: M15924

19.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Clean and touch up the D2563 (B34346A) step as necessary with Imron White, as per QSI005.

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect the touch-up.

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels and paper work necessary with the new batch # @ CHG001

Identify and pack for shipping as per PPP D205-633-025

Location: 70

PPP Rev: A

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART		TEL : 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D205-633-025	CHG	CHG001
DESC.	Heli-Access-Step, LH	STC	SH96-57
LOT	B34975	STC	SR00592/3NY
MODEL	Bell 205/212/214/412	STC	SR00594NY
MADE IN CANADA			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:35:21 AM
 User: Kim Johnston

Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACCESS STEP EXT HIGH GEAR
 Job Number : 34975
 Estimate Number : 12874
 P.O. Number :
 This Issue : 10/3/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D205633025
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : DSI 9300 REV B
 Previous Run : 32508 Drawing Revision : B
 Written By :
 Checked & Approved By :
 Comment : Est Rev B Added D3165-1 KJ/JLM 05-09-09
 Material :
 Due Date : 10/30/2007 Qty: 2 Um: Each

Additional Product

New P/W - Labels

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD205-633-025

CHG001

07.10.04

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch: 330543

Need 2 more

4.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: 325967

5.0

D2562005

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: 332575

B23224

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Number: 34975

Part Number: D205633025

Number:



Seq. #: Machine Or Operation: Description:

6.0

D2563

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Step Weldment Assembly

Batch: 34346A

A110/15 SP (2x)

7.0

D31651

Support Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Support Arm

Batch: 334988 - 1232346

CP

8.0

D2565301

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: B26639 - B208485

CP

9.0

D2565303

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: B26640 - B208495

CP

10.0

D2565305

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: B26641 - B208505

CP

11.0

D2565307

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: B26642 - B208515

CP

12.0

D2565309

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Batch: B26643 - B208525

CP

CP 07/10/15 (2)

Wednesday, 10/3/2007 8:35:22 AM
Johnston

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Number: 34975

Part Number: D205633025

Number:



Seq. #:

Machine Or Operation:

Description:

13.0

D3437045

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Aft Strut Assembly

Batch: B34294

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M100857 - M5247

15.0

AN46A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

Batch: M104322 - M16067

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M102140 - M16199

17.0

AN412A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M105143

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M102473

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

EYEBOLT

Batch: M18034

*****ENSURE THIS IS AN44-7A EYEBOLT*****

Process Sheet

Form: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 34975

Part Number: D205633025

Number:



Seq. #: Machine Or Operation: Description:

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

21.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M101291

22.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer

Batch: M104746

23.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch: M104156

24.0

MS21042L4

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

Nut

Batch: M104683

25.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M104812

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CP 07/10/15 (12)